

36

## Work Order ID 70779



Page 1

Wednesday, June 15, 2011 9:11:11 AM

Item ID: D3794-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 6/15/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 6-15-11 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3794

Rev A

100

0.00



FLOW WATER JET

Waterjet:

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: ☒ ☐ Prog Rev: ☒ ☐ 2-  
Deburr if necessary

B11-6-29

(24)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-29

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 6/16/29

counted  
(+24)

**Work Order ID 70779**

Wednesday, June 15, 2011 9:11:11 AM

Page 2

Item ID: D3794-1

Accept

Revision ID:

Item Name: Gasket

Start Date: 6/15/2011 Start Qty: 20.00

Required Date: 6/22/2011 Req'd Qty: 20.00



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP</u>  Memo	0.00  0.00				11/7/4	<u>SP</u>		(240)
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/7/4 <u>SP</u> C21107109

# Picklist Print

Wednesday, June 15, 2011 9:11:17 AM

Page 1

Work Order ID: 70779

Parent Item: D3794-1

Parent Item Name: Gasket



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MNEO60S.063

Purchased

No

100

sf

466.6800

0.5902

13.11556

15,



13116-09

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

466.68

117295

66.68

118026

400

118026

24



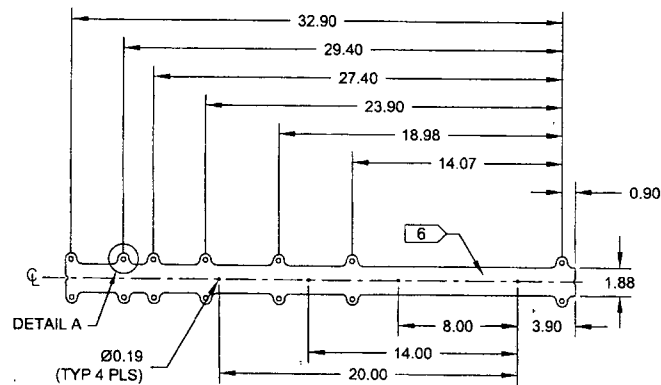
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

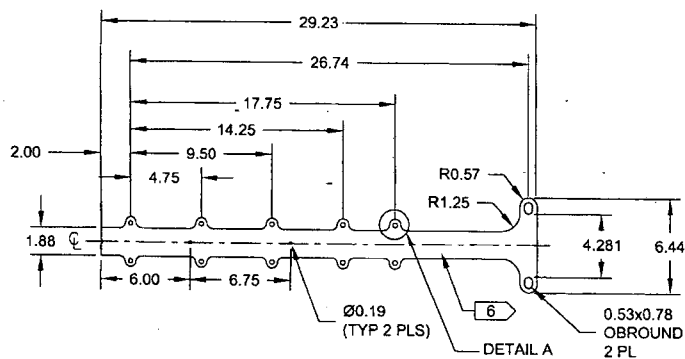
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



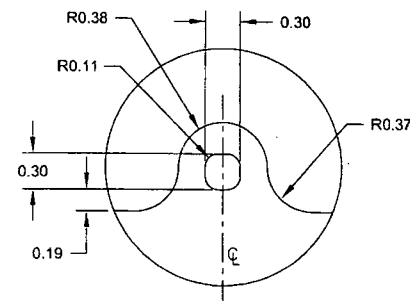
**D3794-1 GASKET**



**D3794-3 GASKET**

**NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS



**DETAIL A**  
SCALE 8X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76719

*PH-0615*

**RELEASED**  
*08-05-14*

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWING NO. D3794	REV. A SHEET 1 OF 1
TITLE GASKET	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries